

AMENDMENT NO. 1 JANUARY 1991
TO
IS 11937 : 1987 SPECIFICATION FOR CARBIDE TIPPED MACHINE
JIG REAMER WITH MORSE TAPER SHANK

(Page 1, clause 5.1) — Substitute the following for the existing clause:

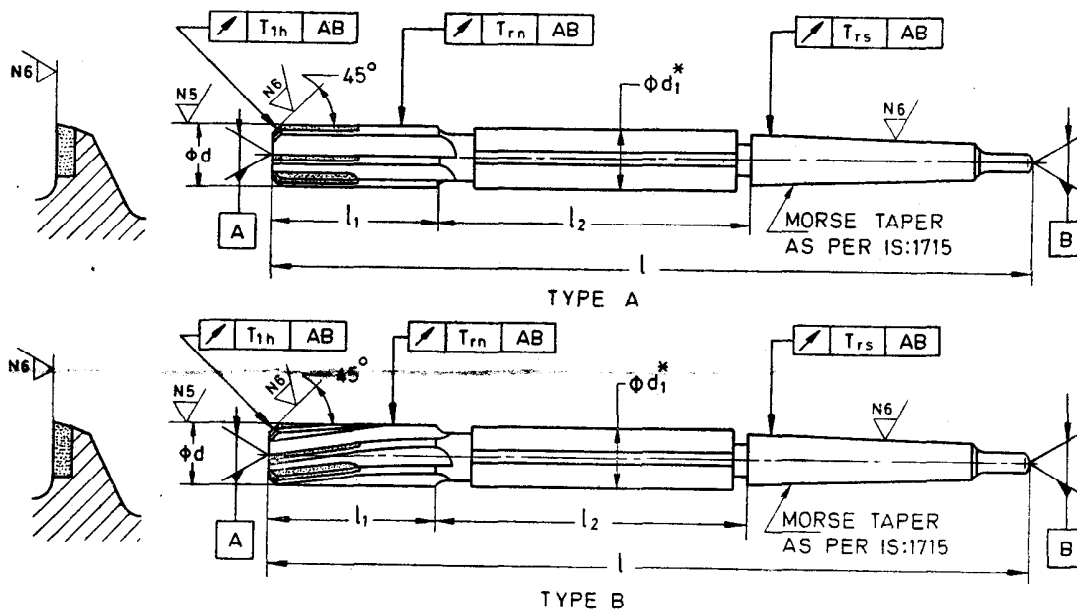
"5.1 Back Taper — Reamers shall be provided with back taper on cutting diameter and the rate of taper shall be as given in 6.2 of IS 10923 : 1984 'Technical supply conditions for carbide tipped and solid carbide reamers'."

(Page 2, Table 1) — Substitute the following for the existing table:

TABLE 1 DIMENSIONS FOR CARBIDE TIPPED MACHINE JIG REAMER WITH MORSE TAPER SHANK

All dimensions in millimetres.

N9/ (N5/ , N6/)



d m6	Range of Diameter		l_1	l_2	l	Morse Taper	No. of Flutes	Carbide Tip
	Over	Up to and Including						
7.0	6.7	7.5	31	53	150	1	4	R 16
8.0	7.5	8.5	33	57	156			
9.0	8.5	9.5	6	60	162			
10.0	9.5	10.6	38	64	168		6	R 19
11.0	10.6	11.8	41	68	1			
12.0	11.8	13.2	44	72	132			
(13.0)			44	72	182			
14.0	13.2	14.0	47	76	189			

(Continued)

TABLE 1 DIMENSIONS FOR CARBIDE TIPPED MACHINE JIG REAMER WITH MORSE TAPER SHANK — Contd

d m6	Range of Diameter		l ₁	l ₂	l	Morse Taper	No. of Flutes	Carbide Tip	
	Over	Up to and Including							
(15·0)	14·0	15·0	50	74	204	2	6	R 19	
16·0	15·0	16·0	52	78	210			R 22	
(17·0)	16·0	17·0	54	80	214				
18·0	17·0	18·0	56	83	219				
(19·0)	18·0	19·0	58	85	223				
20·0	19·0	20·0	60	88	228				
(21·0)	20·0	21·2	62	90	232			R 25	
22·0	21·2	22·4	64	93	237				
(23·0)	22·4	23·6	66	95	241				
(24·0)	23·6	25·0	68	101	268	3	8		
25·0			68	101					
(26·0)	25·0	26·5	70	104	273				
(27·0)	26·5	28·0	70	104					
28·0			71	107	277				
(30·0)	28·0	31·5	73	109	281				
32·0	31·5	33·5	77	116	317			4	10
(34·0)	33·5	35·5	78	119	321				
(35·0)			78	119	321				
36·0	35·5	37·5	79	122	325				
(38·0)	40·0	40·0	81	124	329				
40·0			81	124	329				
(42·0)			82	127	333				
(44·0)	42·5	45·0	83	129	336				
45·0			83	129	336				
(46·0)	45·0	47·5	84	132	340				
(48·0)	47·5	50·0	86	134	344				
50·0			86	134	344				

Note — Non-preferred sizes are given in parentheses.

*The diameter d_1 shall be equal to the diameter of the reamer with a tolerance of h6. However, the actual diameter d_1 shall not exceed diameter d .